

Date: Wednesday, 27/05/2009 8:47:07 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET RIB
Job Number	: 48215		
Estimate Number	: 10402		
P.O. Number	:	Part Number	: D31661
This Issue	: 27/05/2009 S.O. No. :	Drawing Number	: D3166 REV.A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A2
Previous Run	: 47956	Material	:
Written By	:	Due Date	: 02/06/2009 Qty: 12 Um: Each
Checked & Approved By	: <u>040 09-05-27</u>		
Comment	: Est. A 02.08.23 New issue KJ Est: B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ Verified by: EC Est Rev:C 09-01-23 as per DEO D3166-A2 DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
	<i>* (New Entry) End bar Scrap = 1.5</i> Comment: Qty.: 5.2500 f(s)/Unit Total : 63.0000 f(s) 304 SQ Tube.75x.75x.065W (M304TS0750W065) Material: 304/316 SS tube 0.065" wall Batch <u>M111432</u> <i>SAD 09-05-27 (12)</i>	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1 Cut 3/4" x 3/4" square tubing 60.00" long. <i>SAD 09-05-27 (12)</i>	
3.0	BENDING	BENDING MACHINE - SKIDTUBES
	Comment: BENDING MACHINE -Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004. <i>K 9-6-8 (12)</i>	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302) <i>S 09/06/08 (12)</i>	
5.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <del>SEA</del> Basket cell <i>SAD 09-05-08 (12)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 27/05/2009 8:47:07 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET RIB

Job Number: 48215

Part Number: D31661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

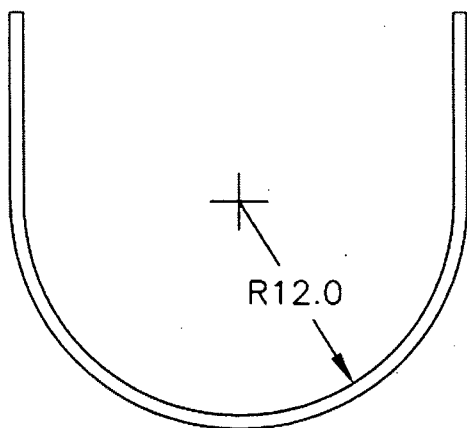
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/-1 WAS 36.0	

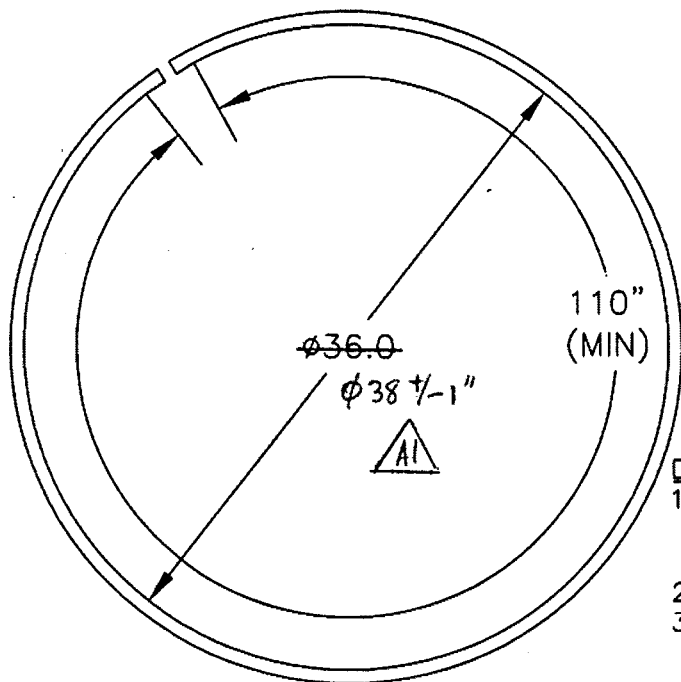
RELEASED  
02.08.06



10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



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WITHOUT NOTICE  
WORK ORDER  
NO. 48215

D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3166	TITLE BASKET HOOP	REV A1	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D3166-A-2	SHEET NO. 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.12.11	DATE 08.12.15	DATE 08/12/15	DATE 08/12/16		DATE 08-12-16		

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

**IS:**

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
60.00" LONG  
REF. DART SPEC M304TS0.750W.065

**WAS:**

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

**IS:**

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
120.00" LONG  
REF. DART SPEC M304TS0.750W.065

**WAS:**

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

NO. 48215  
WORK ORDER  
WITHOUT NOTICE  
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REASON: SEE PAR 08-005

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries